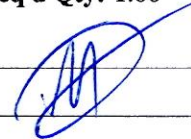


Work Order ID 158219

Wednesday, March 15, 2017 4:02:15 PM

158219

Page 1

Item ID: D4272-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Assembly, Heavy Duty Lid, RH
Start Date: 4/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/10/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED
Approvals: Process Plan:  Date: MAR 15 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4272	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	1.44							
Hand Finishing	TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 2								
	RIVET PLACARD AS PER DWG ON SHEET 2								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.02							
Quality Control									

APR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Work Order ID 158219

Wednesday, March 15, 2017 4:02:15 PM

158219

Page 2

Item ID: D4272-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Assembly, Heavy Duty Lid, RH
Start Date: 4/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/10/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

SmB
17/4/20

17/4/24

DAS
21
9-89

APR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Wednesday, March 15, 2017 4:02:13 PM

Page 1

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.19 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97447A010 *97447A010* Blind Rivet		Purchased	No			100	Each	132.0000	4	4	DAS 6 9-89	APR 19 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST589		132							
				m131311		132							
AN3-16A *AN3-16A* Bolt		Purchased	No			100	Each	71.0000	2	2	DAS 6 9-89	APR 19 2017	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		37							
				117441		37							
				ST348		34							
				M136665		34							
D3914-041 *D3914-041* Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			
D4273-042 *D4273-042* Basket Base Assembly, RH		Manufactured	No			100	Each	0.0000	1	1			
D4307-250 *D4307-250* Placard, Max Load		Manufactured	No			100	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST091		7							
				143815		1							
				151619		6							
								10/14/2017					

B158220 (1x) all 4/6/120
B158221 (1x) all 4/6/120

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Wednesday, March 15, 2017 4:02:13 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D2530 Manufactured No

100 Each

0.0000

1

1

D2530

Handle Weldment

**

157464

APR 19 2017

D2535 Manufactured No

100 Each

62.0000

2

2

D2535

Spring

**

DAS 9-89

APR 19 2017

Location

Loc Qty

Loc Code

ST008

62

153928

25

155434

37

D2537 Manufactured No

100 Each

87.0000

2

2

D2537

Bushing

**

DAS 9-89

APR 10 2017

Location

Loc Qty

Loc Code

ST008

87

152293

4

154171

20

155579

63

D2690-6 Manufactured No

100 Each

19.0000

2

2

D2690-6

Lanyard

**

APR 19 2017

Location

Loc Qty

Loc Code

ST009

19

157312

19

158132

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : ☐																																																															

Picklist Print

Wednesday, March 15, 2017 4:02:13 PM

Page 3

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 100 Each 1,426.000 2 2

D2931

Bumper

**

APR 19 2017

DAS
6
8.00

Location	Loc Qty	Loc Code
ST013	103	
86435	103	
ST025A	1323	
86435	1323	

2

D3912-041 Manufactured No 100 Each 8.0000 1 1

D3912-041

Eyebolt Receiver Assembly

**

APR 19 2017

DAS
6
8.00

Location	Loc Qty	Loc Code
ST057	4	
155653	4	
ST064A	4	
155652	4	

1

D3917-3 Manufactured No 100 Each 123.0000 6 6

D3917-3

Washer

**

APR 19 2017

DAS
6
8.00

Location	Loc Qty	Loc Code
ST058	123	
154158	70	
155753	53	

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D3953-3 Manufactured No

100

Each

38.0000

2

2

D3953-3

Gas Spring Stud, Lid

**

APR 19 2017

DAS
6
3-89LocationLoc QtyLoc Code

ST062

6

152309

1

154178

5

ST064A

32

155380

32

2

D3953-7 Manufactured No

100

Each

111.0000

2

2

D3953-7

Spring Spacer

**

APR 19 2017

DAS
6
3-89LocationLoc QtyLoc Code

ST062

31

153780

31

ST064A

80

154160

54

155761

26

2

D3953-9 Manufactured No

100

Each

26.0000

2

2

D3953-9

Gas Spring Washer

**

APR 19 2017

DAS
6
3-89LocationLoc QtyLoc Code

ST062

26

154172

4

155377

22

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No

100 Each 48.0000 2 2

D3953-17

Gas Spring Spacer

DAS

APR 19 2017

Location Loc Qty Loc Code

ST062 15

155261 15

ST064A 18

154777 18

ST62 15

153987 15

D3953-19 Manufactured No

100 Each 29.0000 1 1

D3953-19

Gas Spring Bracket

DAS

APR 19 2017

Location Loc Qty Loc Code

ST062 2

153480 2

ST064A 27

154207 5

154208 5

154776 5

155258 12

D3953-21 Manufactured No

100 Each 27.0000 1 1

D3953-21

Gas Spring Bracket

DAS

APR 19 2017

Location Loc Qty Loc Code

ST063 27

152996 5

154213 6

154310 10

155275 6

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No 100 Each 18.0000 1 1

D3969-3

Spring (Basket Lid)

Location Loc Qty Loc Code

ST364 6

155911 6

ST369 12

151625 12

D4021-5 Manufactured No 100 Each 16.0000 1 1

D4021-5

Blanking Plate

Location Loc Qty Loc Code

ST071 16

155240 10

156433 6

D4150-041 Manufactured No 100 Each 9.0000 1 1

D4150-041

Attachment Arm Assembly

Location Loc Qty Loc Code

ST087 4

155318 4

ST090A 5

155750 5

D4151-041 Manufactured No 100 Each 9.0000 1 1

D4151-041

Basket Fwd Hardpoint Assembly, Lower

Location Loc Qty Loc Code

ST087 3

156338 3

ST090A 6

155679 6

DAS
6
9-89

APR 19 2017

DAS
6
9-89

APR 19 2017

DAS
6
9-89

APR 19 2017

DAS
6
9-89

APR 19 2017

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

D4151-043 Manufactured No

100 Each 8.0000 1 1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

ST088

8

155833

6

157008

2

AN3-10A Purchased No

100 Each 167.0000 3 3

AN3-10A

Bolt

**

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

GA

63

m136787

63

over003

100

m136665

100

ST349

4

m136192

4

AN3-14A Purchased No

100 Each 72.0000 4 4

AN3-14A

Bolt

**

DAS
6

APR 19 2017

Location

Loc Qty

Loc Code

over003

50

m134852

0

m136838

50

ST349

22

m136406

22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 100 Each 55.0000 3 3

AN4-12

Bolt

Location	Loc Qty	Loc Code
over003	40	
m136199	40	
ST344	15	
m136851	15	

DAS

6

9-09

137138

APR 19 2017

AN4-13A Purchased No 100 Each 236.0000 6 6

AN4-13A

Bolt

Location	Loc Qty	Loc Code
FG	20	
122808	20	
GA	76	
m134634	19	
m135470	57	
ST344	140	
m136787	140	

DAS

6

9-09

137321

APR 19 2017

AN4C15 Purchased No 100 Each 20.0000 1 1

AN4C15

Bolt

Location	Loc Qty	Loc Code
ST343	20	
M136182	20	

DAS

6

9-09

1

APR 19 2017

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No 100 Each 160.0000 4 4

AN5-17A

Bolt

DAS

6
9-99

APR 19 2017

Location Loc Qty Loc Code

GA	20	
117872	20	
over003	75	
m136986	75	
ST337	65	
<u>m136648</u>	65	

4

AN310-4 Purchased No 100 Each 56.0000 3 3

AN310-4

Nut

APR 19 2017

Location Loc Qty Loc Code

GA	25	
M127815	25	
ST331	31	
M136648	31	

3

AN310C4 Purchased No 100 Each 66.0000 3 3

AN310C4

Nut

APR 19 2017

Location Loc Qty Loc Code

ST331	66	
M135895	16	
<u>M136450</u>	25	
M136986	25	

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, March 15, 2017 4:02:14 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

100

Each

448.0000

2

2

MS20600-AD4W3

Cherry Rivet

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

ST308

180

m135603

180

WA003

268

m136648

268

2

MS21042L3

Purchased

No

100

Each

967.0000

9

9

MS21042L3

Nut

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

222

m134360

102

M136665

120

OVER007

300

m134360

0

M136665

300

ST303

345

M136554

344

M136838

1

137073

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 158219

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Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4 Purchased No 100 Each 1,555.000 6 6

MS21042L 4

Nut

DAS
6
9.00

APR 19 2017

Location	Loc Qty	Loc Code
FP001	18	
m133363	18	
GA	183	
m135058	183	
OVER007	500	
m136986	500	
ST303	854	
m136450	500	
m136838	354	

MS21042L5 Purchased No 100 Each 248.0000 4 4

MS21042L 5

Nut

APR 19 2017

Location	Loc Qty	Loc Code
GA	21	
m127813	21	
ST303	227	
m136450	2	
m136866	75	
m136986	150	

DAS
6
9.00

MS24665-151 Purchased No 100 Each 119.0000 4 4

MS24665-151

Cotter Pin

APR 19 2017

Location	Loc Qty	Loc Code
GA	60	
m128401	60	
ST289	59	
m136444	59	

DAS
6
9.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Page 12

Wednesday, March 15, 2017 4:02:14 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

59.0000

2

2

MS24665-300

COTTER PIN

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

GA

28

118234

28

ST288

31

m135046

31

2

NAS1149DN832J

Purchased

No

100

Each

1,046.000

2

2

NAS1149DN832J

Washer

DAS
6
9-89

APR 19 2017

Location

Loc Qty

Loc Code

ST264

1046

M135297

1046

2

NAS1149F0332P

Purchased

No

100

Each

1,299.000

14

14

NAS1149F0332P

Washer

APR 19 2017

Location

Loc Qty

Loc Code

GA

335

m133709

335

ST262

964

m136835

964

137075

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Page 13

Wednesday, March 15, 2017 4:02:14 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

1,866.000

2

2

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136986

1000

ST266

493

m136182

493

NAS1149F0432P

Purchased

No

100

Each

655.0000

18

18

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST262

655

M136442

655

NAS1149C0463R

Purchased

No

100

Each

273.0000

3

3

NAS1149C0463R

Washer

Location

Loc Qty

Loc Code

FP001

25

m127306

25

ST266

248

m134167

48

m136263

200

DAS
9-80

APR 19 2017

DAS
9-80

APR 19 2017

DAS
9-80

APR 19 2017

Wednesday, March 15, 2017 4:02:14 PM

Shop Packet Print

Page 13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Page 14

Wednesday, March 15, 2017 4:02:14 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

251.0000

4

4

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST2360A

200

m136983

200

ST262

51

m134852

51

NAS1515H4L

Purchased

No

100

Each

407.0000

2

2

***NAS1515H4L ***

Washer

Location

Loc Qty

Loc Code

FG

23

103691

3

m132189

20

ST260

71

m131026

8

m131697

63

ST260a

313

m132189

87

m133483

138

m134376

88

Wednesday, March 15, 2017 4:02:15 PM

Shop Packet Print

Page 14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
QC / QA Coordinator Approval																					
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OTHER :																					

Picklist Print

Page 15

Wednesday, March 15, 2017 4:02:15 PM

Work Order ID: 158219

158219

Parent Item: D4272-012

D4272-012

Parent Item Name: Basket Assembly, Heavy Duty Lid, RH

Start Date: 4/6/2017

Required Date: 4/10/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased

No

100

Each

40.0000

2

2

MS17984-C413

Quick Release Pin

DAS
6 APR 19 2017
9-89

Location

Loc Qty

Loc Code

over005

35

154890

5

155448

10

156719

10

157733

10

ST315

5

153942

5

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

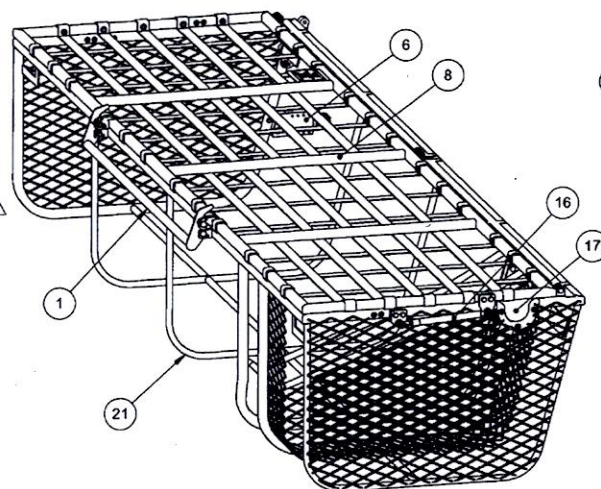
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ITEM	QTY -011	QTY -012	QTY -013	QTY -014	PART NUMBER	DESCRIPTION
					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
					D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
					D4272-013	BASKET ASSY, LIGHTWEIGHT LID, LH
					D4272-014	BASKET ASSY, LIGHTWEIGHT LID, RH
1	1	1	1	1	D2530	HANDLE WELDMENT
2	2	2	2	2	D2535	SPRING
3	2	2	2	2	D2537	BUSHING
4	2	2	2	2	D2690-6	LANYARD
5	2	2	2	2	D2931	BUMPER
6	1	1	1	1	D3912-041	EYEBOLT RECEIVER ASSY
7	1	1			D3914-041	BASKET LID ASSY
8			1	1	D3915-041	LIGHT LID ASSY
9	6	6	6	6	D3917-3	WASHER
10	2	2	2	2	D3953-3	GAS SPRING STUD, LID
11	2	2	2	2	D3953-7	GAS SPRING SPACER
12	2	2	2	2	D3953-9	GAS SPRING WASHER
13	2	2	2	2	D3953-17	GAS SPRING SPACER
14	1	1	1	1	D3953-19	GAS SPRING BRACKET
15	1	1	1	1	D3953-21	GAS SPRING BRACKET
16	1	1	1	1	D3969-3	GAS SPRING
17	1	1	1	1	D4021-5	BLANKING PLATE
18	1	1	1	1	D4150-041	ATTACHMENT ARM ASSY
19	1	1	1	1	D4151-041	BASKET HARDPOINT ASSY (LOWER)
20	1	1	1	1	D4151-043	BASKET HARDPOINT ASSY (UPPER)
21	1	1			D4273-041	BASKET BASE ASSY, LH
22		1		1	D4273-042	BASKET BASE ASSY, RH
23	1	1			D4307-250	PLACARD, MAX LOAD
24			1	1	D4307-265	PLACARD, MAX LOAD
25	3	3	3	3	AN3-10A	BOLT
26	4	4	4	4	AN3-14A	BOLT
27	2	2			AN3-16A	BOLT
28			2	2	AN3-20A	BOLT
29	3	3	3	3	AN4-12	BOLT
30	6	6	6	6	AN4-13A	BOLT
31	1	1	1	1	AN4C15	BOLT
32	4	4	2	2	AN5-17A	BOLT
33			2	2	AN5-21A	BOLT
34	3	3	3	3	AN310-4	NUT, CASTELLATED
35	3	3	3	3	AN310C4	NUT, CASTELLATED
36	2	2	2	2	MS17984-C413	QUICK RELEASE PIN
37	2	2	2	2	MS20600AD4W3	RIVET
38	9	9	9	9	MS21042L3	NUT
39	6	6	6	6	MS21042L4	NUT
40	4	4	4	4	MS21042L5	NUT
41	4	4	4	4	MS24665-151	COTTER PIN
42	2	2	2	2	MS24665-300	COTTER PIN
43	2	2	2	2	NAS1149DN832J	WASHER (ALT: AN960JD8)
44	14	14	14	14	NAS1149F0332P	WASHER
45	2	2	2	2	NAS1149C0432R	WASHER
46	18	18	18	18	NAS1149F0432P	WASHER
47	3	3	3	3	NAS1149C0463R	WASHER
48	4	4	4	4	NAS1149F0563P	WASHER
50	4	4	4	4	97447A010	BLIND RIVET, PAN HEAD

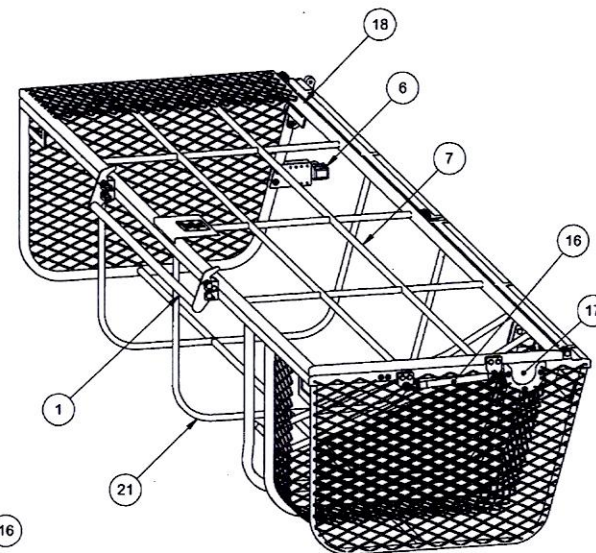
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -011/-012: 73 lbs APPROX
-013/-014: 58 lbs APPROX

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15821900
MAR 15 2017



D4272-013 BASKET ASSY, LIGHTWEIGHT LID, LH (SHOWN)
D4272-014 BASKET ASSY, LIGHTWEIGHT LID, RH (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

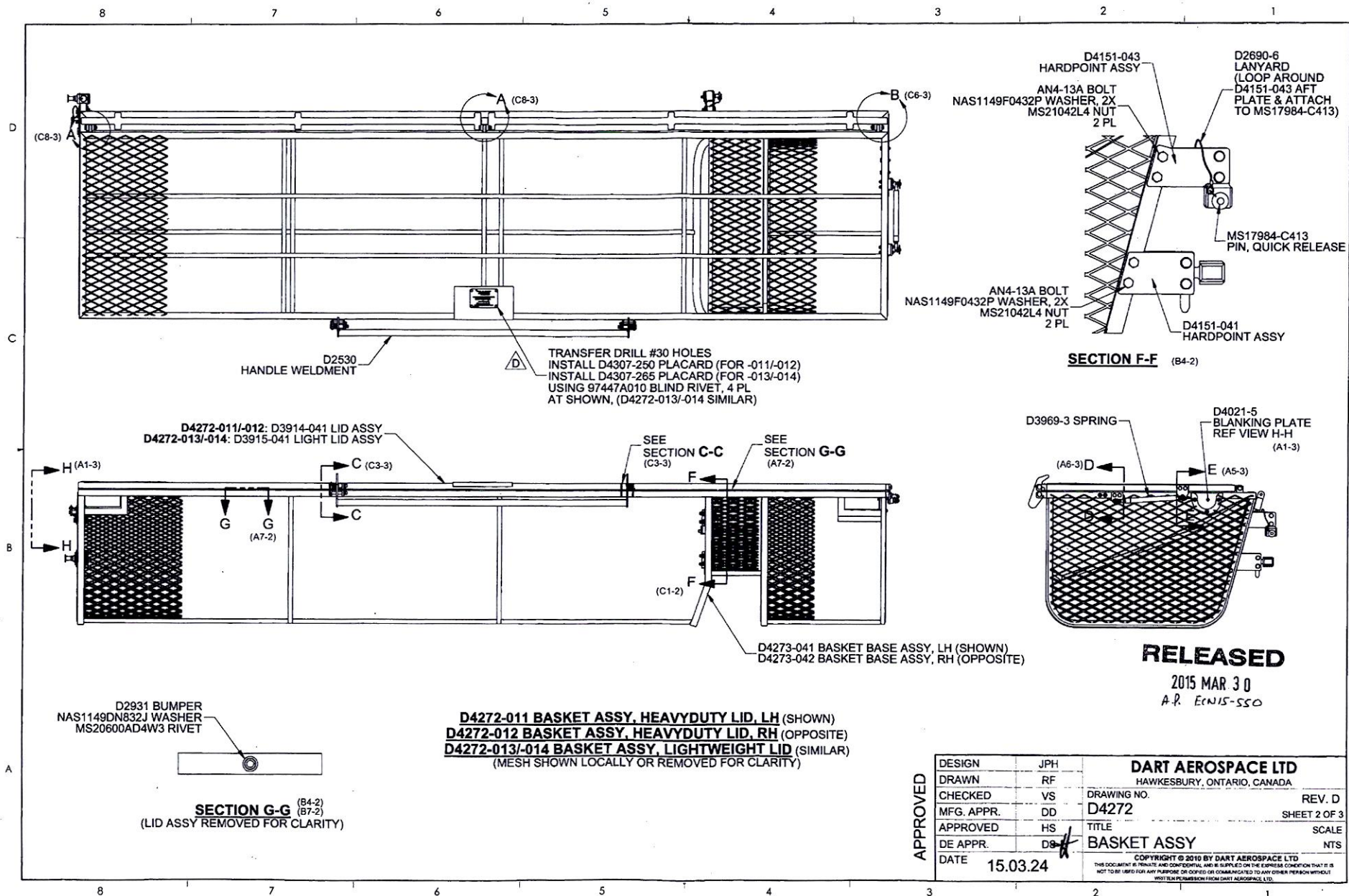


D4272-011 BASKET ASSY, HEAVY DUTY LID, LH (SHOWN)
D4272-012 BASKET ASSY, HEAVY DUTY LID, RH (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

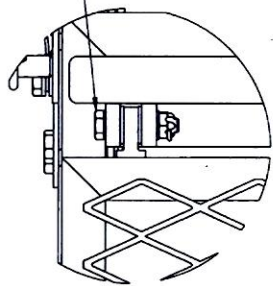
RELEASED

2015 MAR 30
A.R. EN15-550

D	ADDED D4307-250/-265 & 97447A010 (ZN C6-1, A6-1, C5-2)	RF	15.03.24
C	UPDATED D4273-041/-042 BASKET BASE ASSY: CHANGED LOCATION OF GAS SPRING MOUNTING BRACKET; UPDATED SECTION F-F	SC	10.12.23
B	RMV ITEM 23.25 (WEDGE); ITEM 38 QTY(-2); ITEM 44 QTY (-4) (B6-1); RMV D2537 FROM SECTION C-C (TYPO, D3-3)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4272	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET ASSY	NTS
DATE	15.03.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

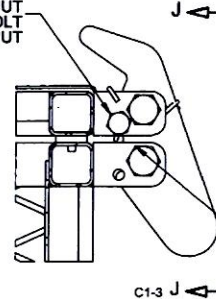


AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A (D8-2)
(D6-2)

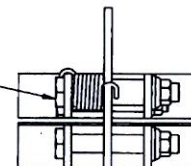
D4272-011/-012: AN3-16A BOLT
MS21042L3 NUT
D4272-013/-014: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C (B5-2)
(B7-2)

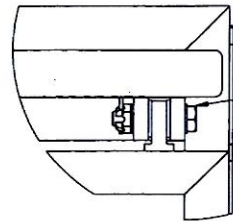
D4272-011/-012: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4272-013/-014: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW J-J C3-3

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



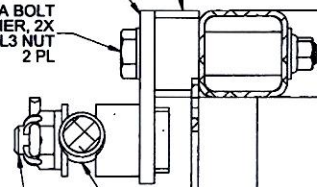
DETAIL B (D3-2)

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



SECTION D-D (B2-2)

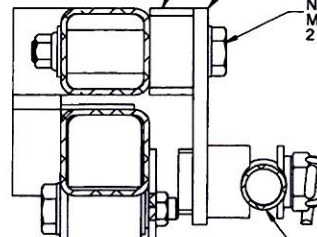
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



SECTION E-E (B1-2)

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

AN3-10A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
3 PL

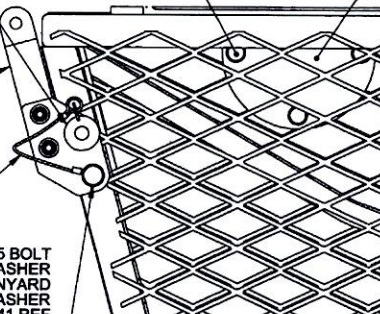
MS17984-C413
PIN, QUICK RELEASE

D4150-041
ARM ASSY

D2690-6
LANYARD
(ATTACH TO
MS17984-C413)

AN4C15 BOLT
NAS1149C0463R WASHER
D2690-6 LANYARD
NAS1149C0463R WASHER
D4150-041 REF
NAS1515H4L WASHER
BASKET BASE, REF
NAS1515H4L WASHER
D4150-041 REF
NAS1149C0463R WASHER
AN310C4 CASTELLATED NUT
MS24665-151 COTTER PIN

D4021-5
BLANKING PLATE
REF



RELEASED

2015 MAR 30
A.P. EN 15-550

VIEW H-H (B8-2)

APPROVED

DESIGN	JPH
DRAWN	RF
CHECKED	VS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	15.03.24

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4272	REV. D SHEET 3 OF 3
TITLE BASKET ASSY	SCALE NTS
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